

Date: Monday, 4/23/2007 1:34:38 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD X-TUBE EXT HEIGHT(-013)
Job Number	: 31971		
Estimate Number	: 10565		
P.O. Number	: N/A	Part Number	: D205596105
This Issue	: 4/23/2007 S.O. No. : N/A	Drawing Number	: D205596105
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: A
Previous Run	: 31377	Material	: N/A
Written By	:	Due Date	: 5/15/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>7.04.23</u>		
Comment	: Est Rev:D 05.03.21 Added bending procedure KJ/JLM		

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy D205-594 bluefile & type labels per PPP D205-596-105 CHG001

KS 07-05-07

①

2.0	D2889	FWD Crosstube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
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1	D2889	Aft Crosstube	31366
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3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

Mark 23.92" for cutting from tangential line in the straight section from D2889 as per Dwg wall template.

EL 7-5-22

4.0	QC15	DIMENSIONAL CHECK OF X-TUBES
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Comment: DIMENSIONAL CHECK OF X-TUBES

07-05-22 ①

5.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut as per Dwg D205-596-105

DP 7-5-23

2-Deburr & Inspect for surface damage. Polish cut surface. Scribe part # and batch # on one end of tube.

JB 7-5-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 31971

Part Number: D205596105

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

7-405-24

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat per QSI 005 4.1

507-5-24

8.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside with Immron per QSI 005 4.2

25 07 -07 -25

9.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

ml 07 07 26

(1)

10.0

D2856600

Abrasion Strip



Comment: Qty.: 1.4895 f(s)/Unit Total : 1.4895 f(s)

Pick:

Qty Part number

Description

Batch

2 D2856-600(8.51")

Abrasion Strip

26650

25 07 -08 17

11.0

D28931

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number

Description

Batch

2 D2893-1

Support

33560

25 07 -08 -17

12.0

MS2192024

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number

Description

Batch

4 MS21920-24

Clamp

103955

25 07 -08 -17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/08/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: FWD X-TUBE EXT HEIGHT(-013)

Job Number: 31971

Part Number: D205596105

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips per QSI 035 position using DT8582. Install supports and clamps per Dwg D205-596-105. Torque clamps to 80-100 in lb.

25 07-08-13

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

in 07/08/22 (e)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-596-105

Location: _____

PPP Rev: _____

CP 07/08/22 SP

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/08/23

Job Completion



U 07-08-23

205 596 105 B 31971

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

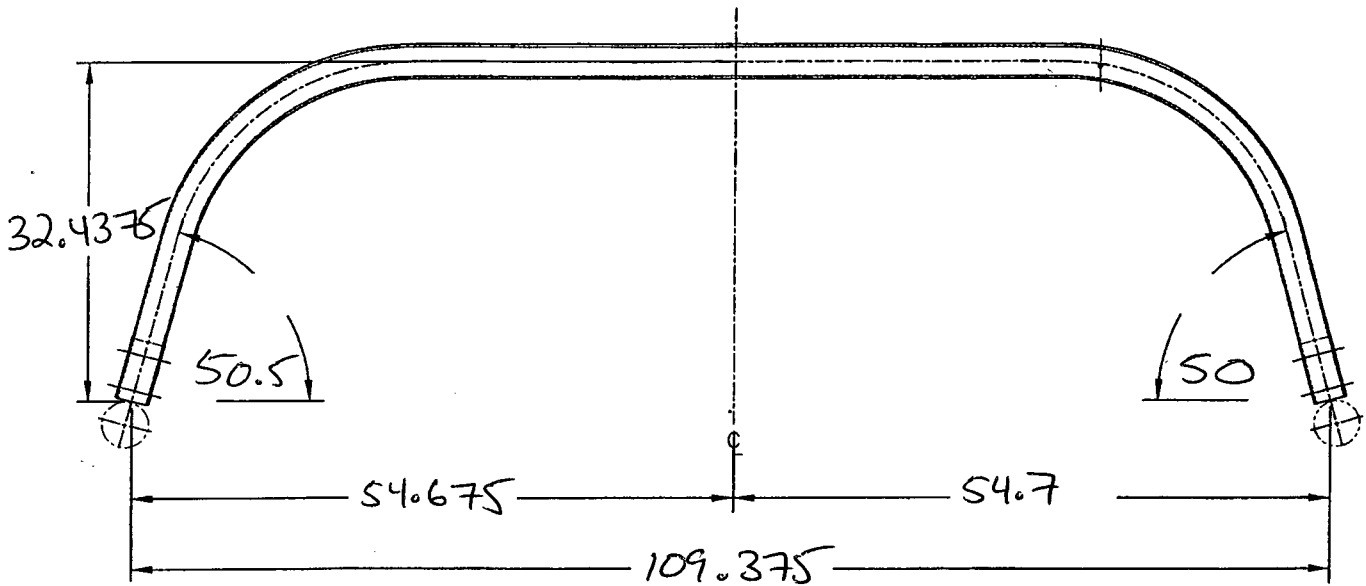
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD.		Work Order:	31971
Description: Crosstube High-High Fwd		Part Number:	D205-596-105
Inspection Dwg: D205-596-105 Rev: A		Page 1 of 1	

Required Dimension	Min	Max
Height	32.4	32.6
1/2 Span	54.6	54.8
Angle	49	52
Total Span	109.2	109.6

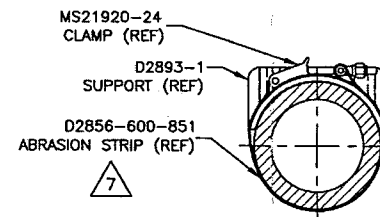
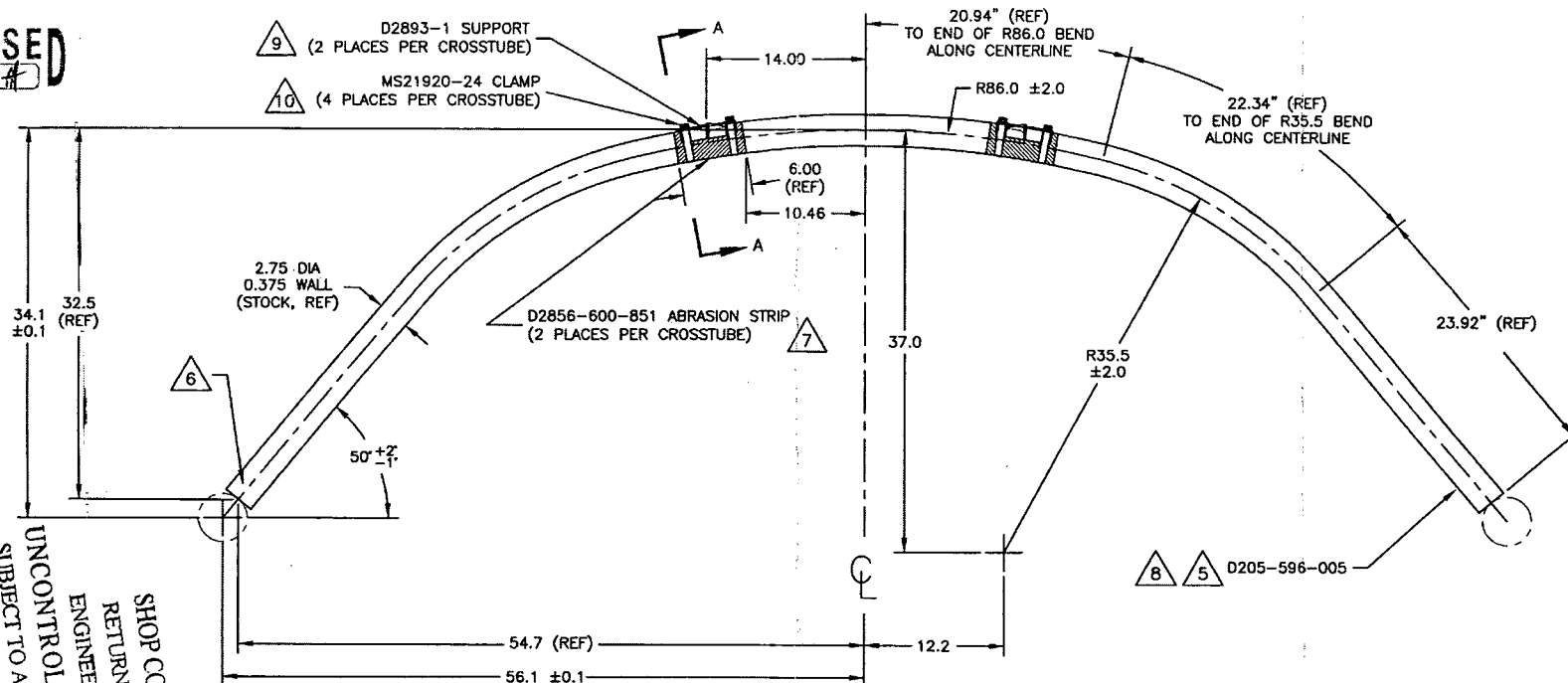


Comments
made from 02889 B31366

QC15 Inspection	<i>[Signature]</i>
Date	070522

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM <i>[Signature]</i>	<i>[Signature]</i>

RELEASED
02-11-21



SECTION A-A
SCALE 2:5

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURE FROM D6005-180
FINISHED LENGTH = 134.40
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 6) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS
- 7) INSTALL D2856-600-851 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2893-1 SUPPORT, PER QSI 035
- 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005\"
- 9) SEAL EDGES OF SUPPORTS USING SIKAFLEX-241/-291 SEALANT (OPTIONAL)
- 10) TORQUE CLAMPS 80 TO 100 IN-LB

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A	02.11.20	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. HARRISBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D205-596-105
DATE	02.11.20	TITLE CROSSTUBE FWD EXTENDED
		REV. A SHEET 1 OF 1 SCALE 1:10

